

Work Order ID 131084

March-26-15 1:40:51 PM

131084

Page 1

Item ID: D407-797-111

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Quick Release Mounting 407 Fits LH or RH

Stop

NS2

Start Date: 3/14/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: MCSDate: 15-03-30

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
IIN-D407-797-1	C								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy bluefile & type labels per PPPD407-797-111-CHG002								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									

MCS 15-12-16

IX DAS 28 DEC 16 2015
9-89IX DAS 27 DEC 15 2015
9-89

DEC 16 2015

IX DAS 28
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

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Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Quick Release Mounting 407 Fits LH or RH

Stop

NS2

Start Date: 3/14/15

Start Qty: 1.00

1

Cust Item ID:

Required Date: 3/26/15

Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Pick Kit

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D407-797-111

Location:

PPP rev:

Sold

PPP 132793

1X

DAS
28
9-89

DEC 16 2015

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

ML5

DEC 17 2015

ML5

DEC 17 2015

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 1

Work Order ID: 131084

131084

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 3/14/15

Required Date: 3/26/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 11.02.09 new issue DD verf:JLM
11.09.12 @ chg 002 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4271-011

Manufactured No

110

Each

5.0000

1

1

D4271-011

Beam Assy, Fwd

**

DAS

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST452

5

103488

1

106051

1

122942

2

123380

1

D4271-013

Manufactured No

110

Each

5.0000

1

1

D4271-013

Beam Assy, Aft

**

DAS

27

9-89

DEC 16 2015

DAS
28
9-89

Location

Loc Qty

Loc Code

ST453

5

113266

1

120126

1

122880

2

123325

1

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Page 2

Work Order ID: 131084

131084

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 3/14/15

Required Date: 3/26/15

Start Qty: 1.00

Required Qty: 1.00

D4292-1

Manufactured No

110

Each

21.0000

2

2

D4292-1

Fitting

DAS
28
9-89

Location

Loc Qty

Loc Code

st533

21

103469

3

113275

4

114191

1

116823

2

119389

5

123358

6

DAS
27
9-89

D4294-1

Manufactured No

110

Each

11.0000

2

2

D4294-1

Fitting

DAS
28
9-89

Location

Loc Qty

Loc Code

st533

11

103467

3

112281

4

119386

4

DAS
27
9-89

D4314-1

Manufactured No

110

Each

62.0000

4

4

D4314-1

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

ST099

62

103656

18

120515

24

123102

20

DAS
27
9-89

DEC 16 2015

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Page 2

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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Page 3

Work Order ID: 131084

131084

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 3/14/15

Required Date: 3/26/15

Start Qty: 1.00

Required Qty: 1.00

D4314-3

Manufactured No

110

Each

66.0000

4

4

D4314-3

Shim

DAS
28
9-89

Location

Loc Qty

Loc Code

ST099

28

108509

20

116106

6

117189

2

ST103a

38

113351

16

119651

8

123115

14

2
2

DAS
27
9-89

AN6-17A

Purchased

No

110

Each

36.0000

2

2

AN6-17A

Bolt

DAS
28
9-89

Location

Loc Qty

Loc Code

ST334

36

m128403

21

m130466

15

2

DAS
27
9-89

AN6-20A

Purchased

No

110

Each

56.0000

2

2

AN6-20A

BOLT

132576

DAS
28
9-89

Location

Loc Qty

Loc Code

ST286A

25

M128936

25

ST334

31

M127044

1

M130466

30

DAS
27
9-89

DEC 16 2015

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Page 3

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Handling/Pre									
Material									
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Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

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131084

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D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 3/14/15

Required Date: 3/26/15

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0663J

Purchased

No

110

Each

1,219.000

8

8

NAS1149D0663J

Washer

**

133131x4

DAS

DAS

133769 XY

8-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST260

1152

M131618

1152

ST269

67

M126334

67

MS21042L6

Purchased

No

110

Each

422.0000

4

4

MS21042L6

Nut

**

133483

DAS

DAS

8-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST273A

200

m131624

200

ST305

22

m129909

1

m130799

21

t260a

200

m131317

200

MS27151-19

Purchased

No

110

Each

31.0000

4

4

MS27151-19

NUT

**

DAS

DAS

8-89

27

9-89

DAS
28
9-89

Location

Loc Qty

Loc Code

ST280

31

121339

4

m128593

5

m128994

20

m129150

2

[Signature]

4

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Shop Packet Print

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DEC 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

March-26-15 1:40:50 PM

Page 5

Work Order ID: 131084

131084

Parent Item: D407-797-111

D407-797-111

Parent Item Name: Quick Release Mounting 407 Fits LH or RH

Start Date: 3/14/15

Required Date: 3/26/15

Start Qty: 1.00

Required Qty: 1.00

MS24694-10

Purchased

No

110

Each

27.0000

4

4

9-89

MS24694-10

SCREW

**

DAS

DAS
28
9-89

Location

Loc Qty

Loc Code

27

9-89

ST290

27

121166

27

110

Each

3.0000

1

1

9-89

D4713-1

Manufactured

No

D4713-1

Spacer

**

DAS
28
9-89

Location

Loc Qty

Loc Code

27

9-89

ST124

3

89836

3

110

Each

100.0000

1

1

9-89

MS3367-5-0

Purchased

No

MS3367-5-0

Tie Wrap

**

DAS
28
9-89

Location

Loc Qty

Loc Code

27

9-89

ST277

100

123164

100

DAS
28
9-89

DEC 16 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

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5.0 PARTS LIST

REFERENCE ONLY

Qty -011	Qty -012	Qty -013	Qty -014	Qty -111	Part Number	Description
X					D407-797-011	QUICK RELEASE HELI-UTILITY-BASKET
	X				D407-797-012	QUICK RELEASE HELI-UTILITY-BASKET
		X			D407-797-013	QUICK RELEASE HELI-UTILITY-BASKET
			X		D407-797-014	QUICK RELEASE HELI-UTILITY-BASKET
1	1	1	1	X	D407-797-111	QUICK RELEASE BASKET MOUNTING KIT
1					D4272-011	BASKET ASSY, HEAVY DUTY LID, LH
	1				D4272-012	BASKET ASSY, HEAVY DUTY LID, RH
		1			D4272-013	BASKET ASSY, LIGHT WEIGHT LID, LH
			1		D4272-014	BASKET ASSY, LIGHT WEIGHT LID, RH
				1	D4271-011	BEAM ASSY, FWD
				1	D4271-013	BEAM ASSY, AFT
				2	D4292-1	FITTING
				2	D4294-1	FITTING
				4	D4314-1	SHIM
				4	D4314-3	SHIM
				1	D4713-1	SPACER
				2	AN6-17A	BOLT
				2	AN6-20A	BOLT
				8	NAS1149D0663J	WASHER (OR AN960JD616)
				4	MS21042L6	NUT (OR MS21042-6)
				4	MS27151-19	NUT
				4	MS24694-10	SCREW
				1	MS3367-5-0	TIE WRAP

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Revision: D

Date: 15.04.14